

Work Order ID 65952-2

Thursday, January 27, 2011 3:29:07 PM



Page 1

Item ID: D3910-3

Accept



Setup Start



Revision ID:

Item Name: Crosstube Lug

Stop



Start Date: 1/28/2011 Start Qty: 30.00

Required Date: 2/18/2011 Req'd Qty: 30.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: *mf*

Date: *11-01-27*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3910

B

100

0.00



Bandsaw

Memo

0.00

Cut to 1.450" Long

Jeaspa Bandsaw

cut @ meter

CD 11/02/03 (30)

110

0.00



HAAS 1

Memo

0.00

MACHINE AS PER FOLIO EA865 AND DWG

FOLIO REV:

DWG REV:

HAAS CNC vertical machine #1

purchasing

DEBURR

machine as per dwg D3910 REV.B

issue #10: 13428 meter

CD 11/02/03 (30)

1/4/14 (10)

Work Order ID 65952

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Page 2

Item ID: D3910-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Lug

Start Date: 1/28/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 2/18/2011 Req'd Qty: 30.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120 R K

QC2- Inspect parts off machine FAT/FATB

0.00



QC

Quality Control

add inspect for transit damage

Memo

attached CAFE to W/O

0.00

4/4/14 (10)

130

QC6 Inspect parts - second check

0.00



QC

Quality Control

Memo

0.00

8.1.02/16

(10)

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Hand Finishing

Memo

0.00

10 6 all 4/02/17

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Page 3

Item ID: D3910-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Lug

Start Date: 1/28/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 2/18/2011 Req'd Qty: 30.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

M115591

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

START: 2:15 pm
Temp: 320°F
FIN 2:45 pm

0.00

10 11/02/12

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

10 BR 11-02-12

170



Packaging

Packaging

Identify as per dwg & Stock Location: 507

0.00

Memo

0.00

10 11/02/12

Work Order ID 65952

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Page 4

Item ID: D3910-3

Accept



Setup Start



Revision ID:

Item Name: Crosstube Lug

Stop



Start Date: 1/28/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 2/18/2011 Req'd Qty: 30.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/22 *[Signature]*
MF
11-02-18

Picklist Print

Thursday, January 27, 2011 3:29:04 PM

Page 1

Work Order ID: 65952



Parent Item: D3910-3



Parent Item Name: Crosstube Lug

Start Date: 1/28/2011

Required Date: 2/18/2011

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD
REV:B AS PER REV B 10-03-23 JLM VERIFIED BY:DD

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2423		Manufactured	No			100	f	519.8114	0.13	4.105263			
-------	--	--------------	----	--	--	-----	---	----------	------	----------	--	--	--



Lug Extrusion



C211/02/03

Location

Loc Qty

Loc Code

MAT06

519.8114265

43722

180

45800

51.8114265

63005

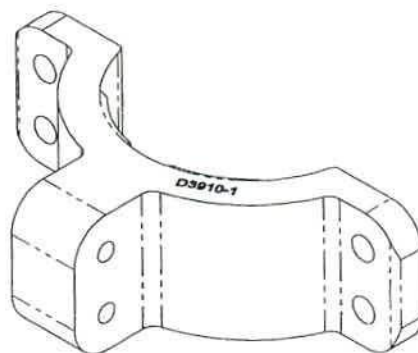
288

4.11

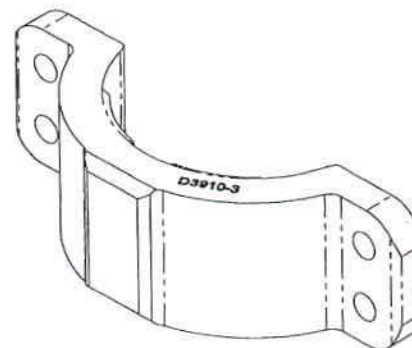
D3910-3P

X30

[Signature]



D3910-1 X-TUBE LUG



D3910-3 X-TUBE LUG

#65952

RELEASED
2010-03-22
MD

NOTES:

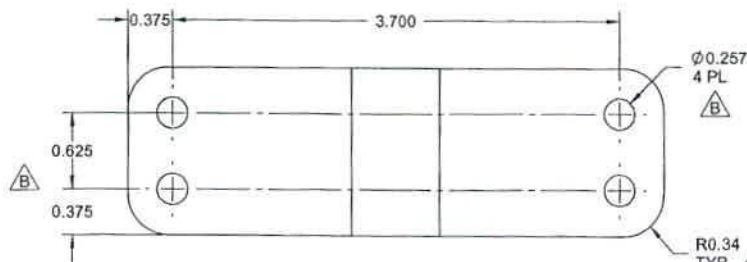
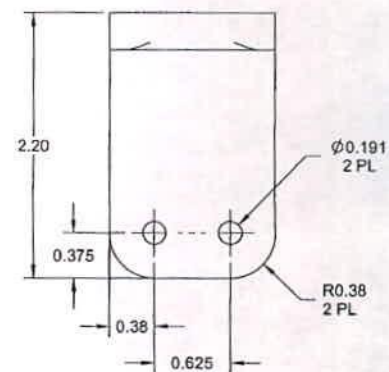
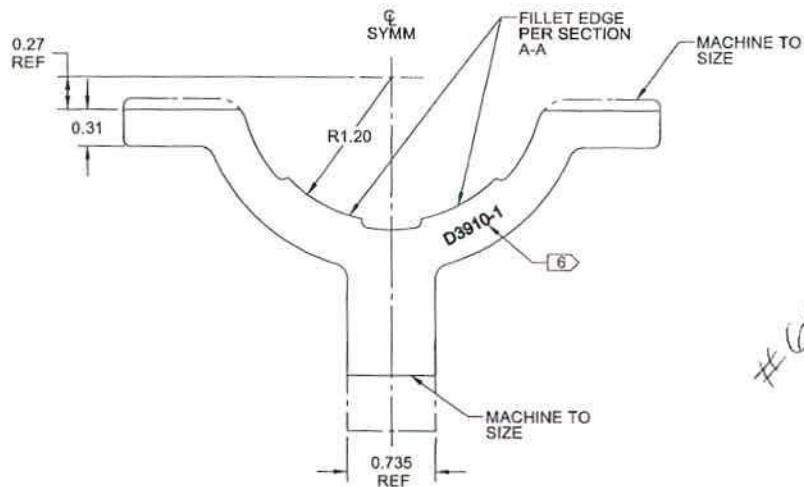
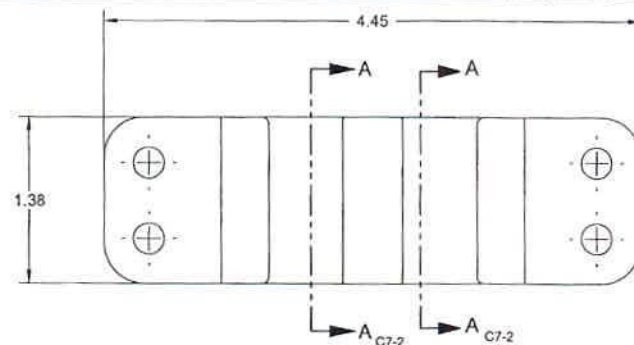
- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 \pm 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 \pm 0.005
- 7) WEIGHT -1: 0.32 lbs
-3: 0.25 lbs

B	Ø0.257 HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3); R0.34 FILLET WAS R0.50 (A3-2) & (A3-3) REASON: SEE TR-D350-807-2		JPH	10.03.16
A	NEW ISSUE		JPH	10.03.04
REV	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	JPH			
CHECKED	JPH	DRAWING NO.	REV. B	
MFG. APPR.		D3910	SHEET 1 OF 3	
APPROVED		TITLE	SCALE	
DE APPR.		X-TUBE LUG (350)	NTS	
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		






ROUND EDGE
R0.06 MIN - R0.10 MAX
2 PL

SECTION A-A
C4-2
C5-2



D3910-1 X-TUBE LUG

RELEASED
2010-03-22
WJP

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3910	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO13428

Purchase Order Date 2/03/11

PO Print Date 2/03/11

Page Number 1 of 1

Order From :

VC-MET003

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, QC K0B 1R0
CA

Contact Name

Vendor Phone

613 678 3957

Vendor Fax

613 678 3956

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

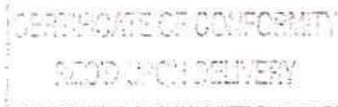
CL 11/02/04

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D3910-3P	Crosstube Lug	2/14/11 Yes	30.00 Each	Yours ppd	\$31.5500	\$946.50

Special Inst: MACHINE AS PER DWG D3910 REV. B
B65952

PO Total:

\$946.50



Change Nbr:

1

Change Date: 2/03/11

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 17763
Date: Feb 14, 2011
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 13428	Sold By: Walz, Christian D.
Shipped By: your truck	Ship Date:

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D3910-3 Crosstube Lug D-2423 B 45800 Material supplied by DART: D2423 B45800	Each	30	10 <i>2/11/2/14</i>	
Received by _____	Thank you for your order!			

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
10	D3910-3	Crosstube Lug	13428
30	D3910-3	Crosstube Lug	13450
	MATERIAL: supplied by DART D2423 B45800		
24	D4091-1	Lug	13326
	MATERIAL: supplied by DART D2423 B63005		

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

5/11/02/16

Shigi Walz

Vankleek Hill, February 14, 2011